Work Order ID 52567

October 1, 2009 2:29:30 PM

Item ID: D3451-045 GN **Accept** **Setup Start**

Revision ID: A **Stop**

Item Name: Handle and Lock-Down Assembly

Start Date: 10/02/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/12/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** 09-10-01 **Date:** MF **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3451	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Notes
100 Large Fab Large Fab	Large Fab **Memo** Weld as per dwg PB67-43001	0.00 0.00	Cpl 09 10 06
110 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds **Memo**	0.00 0.00	PD 09.10.07
120 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	2) S 09/10/06 (x4) ∅

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Work Order ID 52567

October 1, 2009 2:29:30 PM

Item ID: D3451-045 **Accept**

Setup Start

Stop

Revision ID: A

Item Name: Handle and Lock-Down Assembly

Start Date: 10/02/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/12/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00	MD 09/10/06			x4			
140 Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 M 18144 **Memo** START TIME: 9:00 □OVEN TEMPERATURE: 320° □FINISH TIME: 9:30	0.00 0.00	BR 09-10-7			(4)			
150 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00	=> JY 09/10/07			(X4)	Ø		

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: _________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 52567

October 1, 2009 2:29:30 PM

Item ID: D3451-045 **Accept**

Setup Start / Stop

Revision ID: A

Item Name: Handle and Lock-Down Assembly

Start Date: 10/02/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/12/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start / Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Small Fab Small Fab	Small Fab **Memo** 1- assemble rubber handle as per dwg PB67-43001	0.00 0.00				09/10/08			(4)
170 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 2) S 01/10/09				(4)	0		
180 Packaging Packaging	Identify as per dwg & Stock Location: 442 **Memo**	0.00 0.00					9/10/9		(4)

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________________ **PAR #:** _______ **Fault Category:** ___________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ______________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 52567

October 1, 2009 2:29:30 PM

Item ID: D3451-045 **Accept**

Setup **Start**

Revision ID: A

Item Name: Handle and Lock-Down Assembly **Stop**

Start Date: 10/02/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/12/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run **Start**

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00				____	09/10/13		
Quality Control									

JNF

09-10-09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 1, 2009 2:29:29 PM

Work Order ID: 52567

Parent Item: D3451-045RevA

Parent Item Name: Handle and Lock-Down Assembly

Start Date: 10/02/2009 **Required Date:** 10/12/2009

Comments:

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3451-5RevA Tube Handle Arm		Manufactured	No			100	Each	0.0000	8.0000	Cp C09.10.06 B52574 → 8 ✓		
GP-211 Rubber Handle		Purchased	No			100	Each	28.0000	8.0000	E 09/10/08		
PB67-43001-103RevC Tube Handle		Manufactured	No			100	Each	0.0000	4.0000	Cp C09.10.06 B52570 → 4 ✓		

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	28		
109006	4		~~4~~
111076	24		~~24~~ 8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

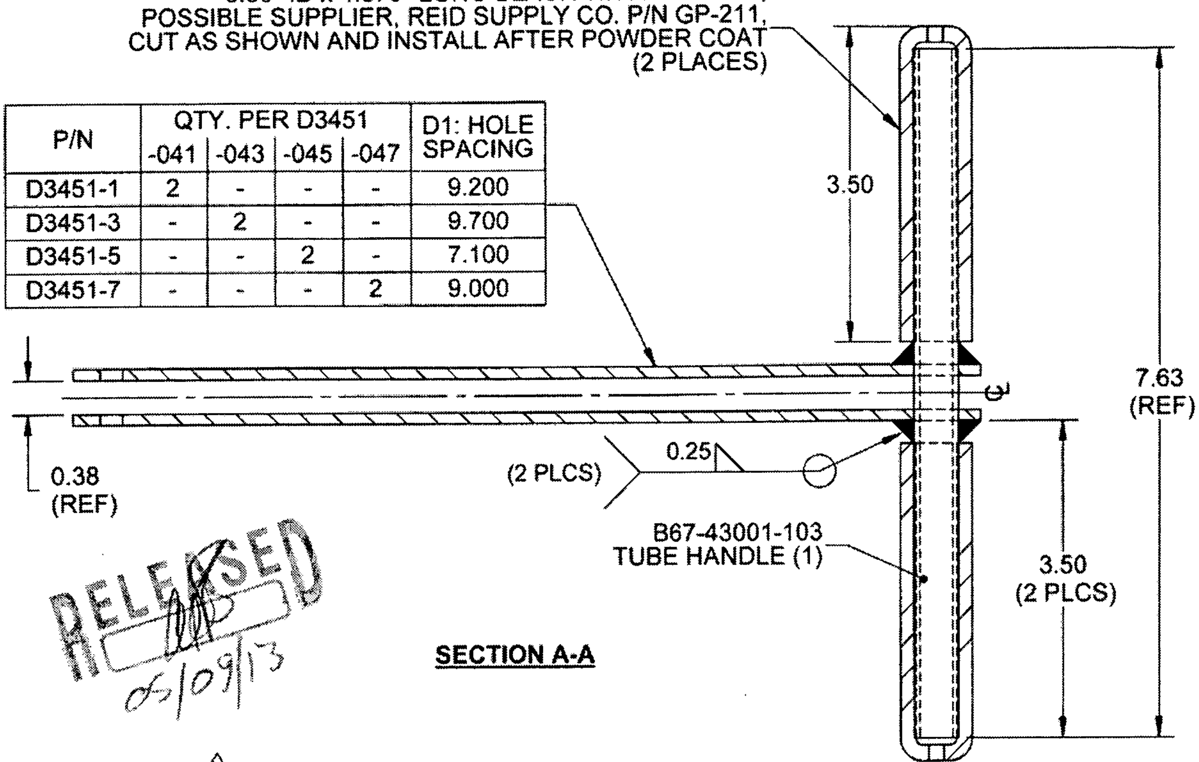
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3451 — REV. A — SHEET 1 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y — SCALE 1:2
A	05.08.25	NEW ISSUE

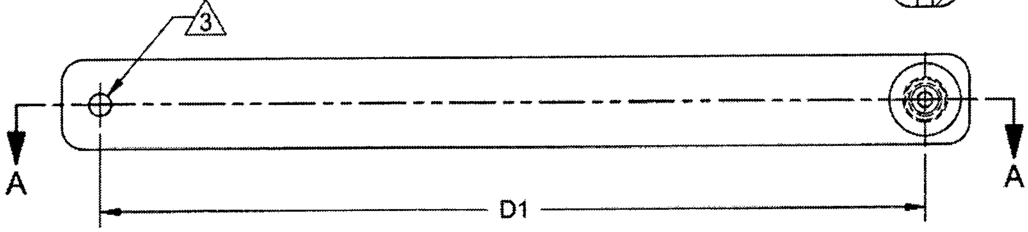
DART

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



RELEASED 05/09/13

SECTION A-A



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41
D3451-045 SUPERSEDES PREMIER P/N B67-43001-39
D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

#52567

NOTES:

1) WELD PER DART QSI 004
2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) MASK BEFORE PAINTING.
4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
5) PART IS SYMETRICAL ABOUT CENTER LINE.
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) ALL DIMENSIONS ARE IN INCHES
8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

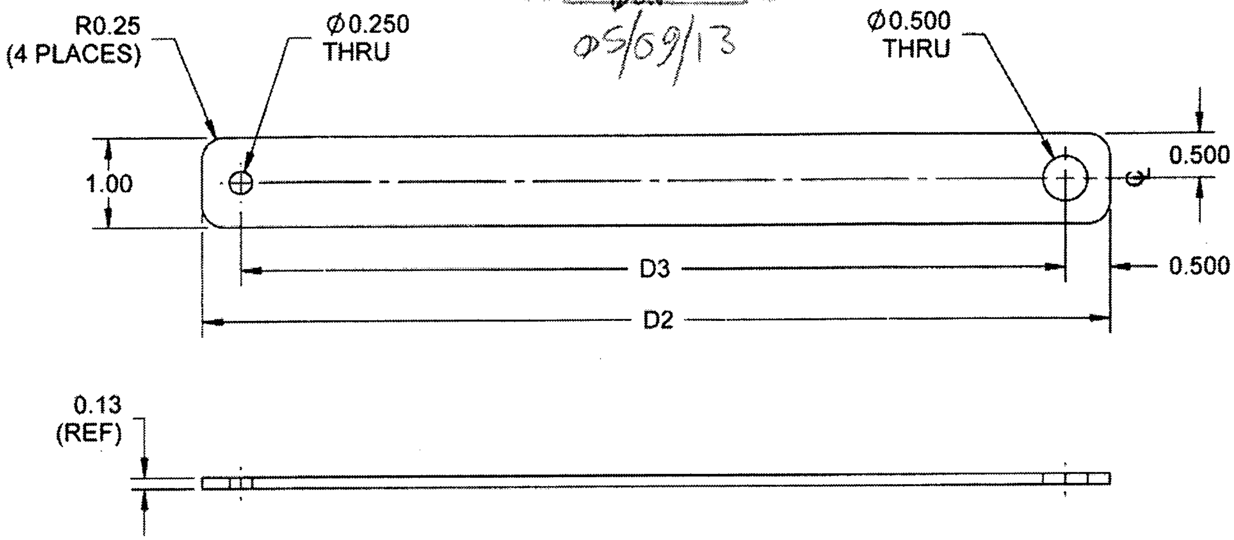
Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3451 REV. A SHEET 2 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2

RELEASED 05/09/13



P/N	D2: CUT LENGHT	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

#5267

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303
D3451-5 SUPERSEDES PREMIER P/N B67-43001-301
D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
2) PART IS SYMETRICAL ABOUT CENTER LINE.
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE